

Work Order ID 86259

86259

Page 1

June-25-12 2:25:22 PM

Item ID: D2656-31

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 25/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/25 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2656

Rev D

(3)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2656 Dwg Rev: D Prog Rev: D 2-
Deburr if necessary

1010 .040

B12-6-20

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-6-20

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sizbee127

(+)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. Identify as D2656-31.

(Signature)

SD 12/07/03

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

512/03/03

(Signature)

150

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320015

1:50

4X4

m/f 12/07/04

m121279

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Required Date: 10/07/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				H	φ	BLD-7-4	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>EP</u> Memo	0.00 0.00				4X		12-7-5	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				OK	12/7/6		

ME
12-07-05

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NOTE: Date & initial all entries

Picklist Print

June-25-12 2:25:26 PM

Page 1

Work Order ID: 86259

86259

Parent Item: D2656-31

D2656-31

Parent Item Name: Wearshoe

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: D02.10.25Re-formatKJ

IPP Rev:E 06-06-12 Now On Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			100	sf	198.0700	0.39	1.642105	2		
M1010S20GA									**				
1010/1025 SHEET												12-6-06	

Location

Loc Qty

Loc Code

MAT019

198.07

111410

26.9

116791

43.17

121780

128

116791

④

Dart Aerospace Ltd

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Dart Aerospace Ltd

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

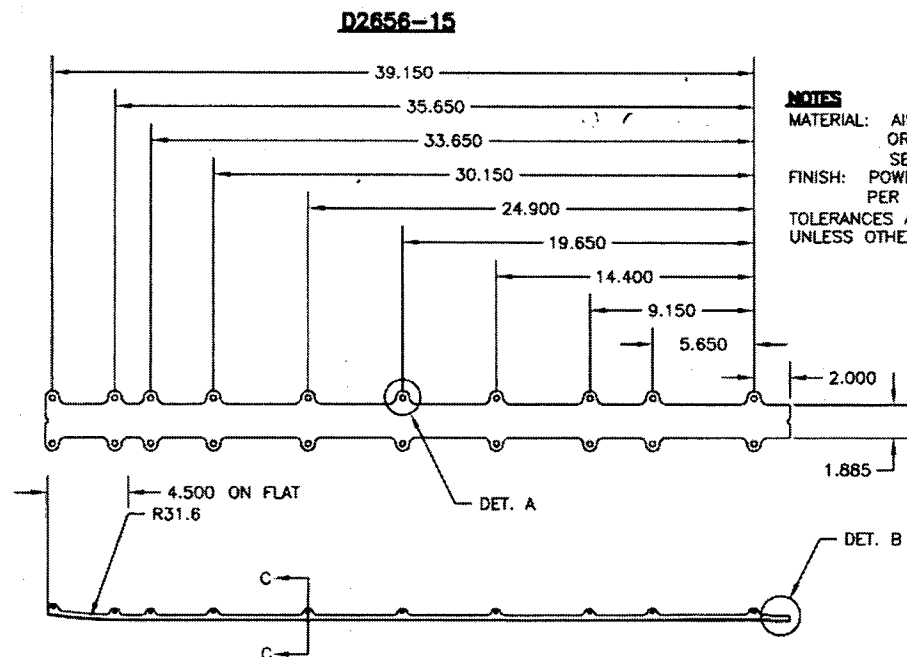
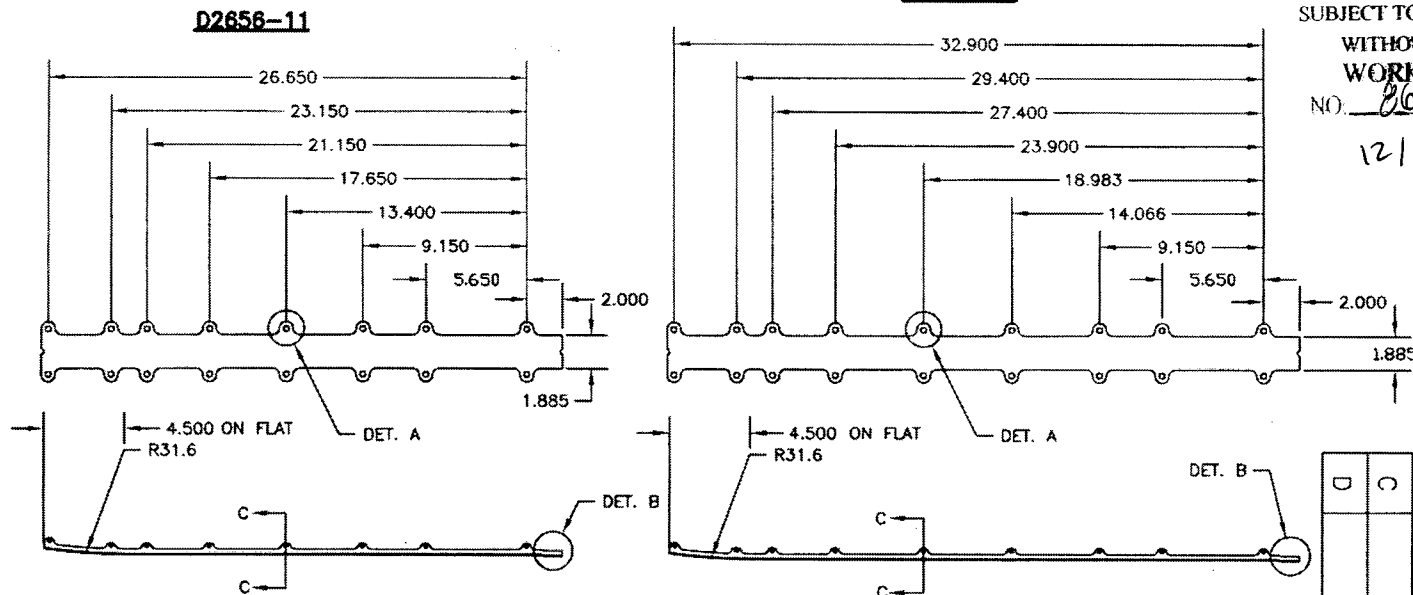
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 80259 MLW
12/06/25

DART



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05-09-06

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CHECKED	APPROVED	DRAWING NO.	REV. D
#	#	D2656	SHEET 1 OF 4
DATE		WEARSHOE	
05.08.17		NEW ISSUE	
		CHANGED TABS	
		R31.6 WAS R19.5	
		ENLARGE ALL HOLES TO IMPROVE FIT	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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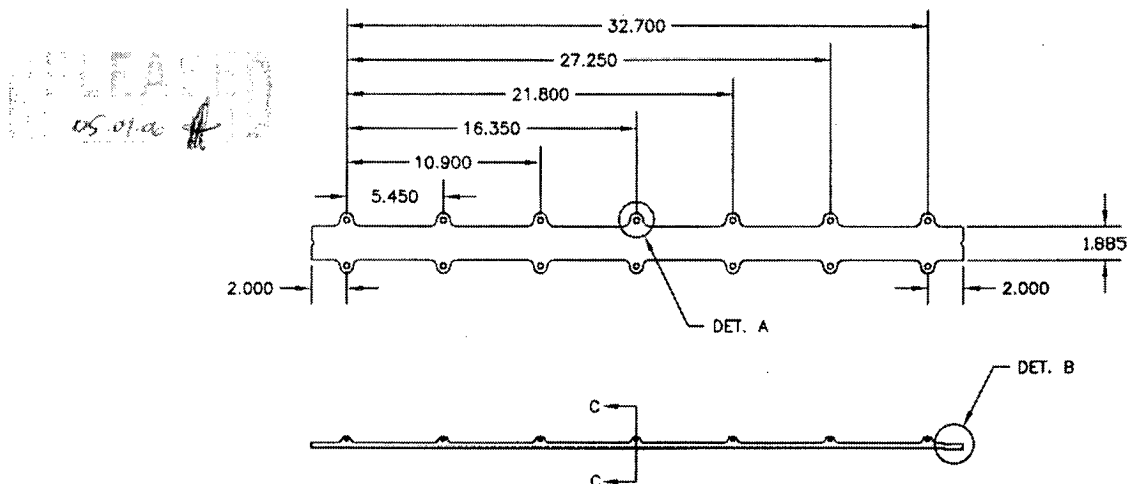
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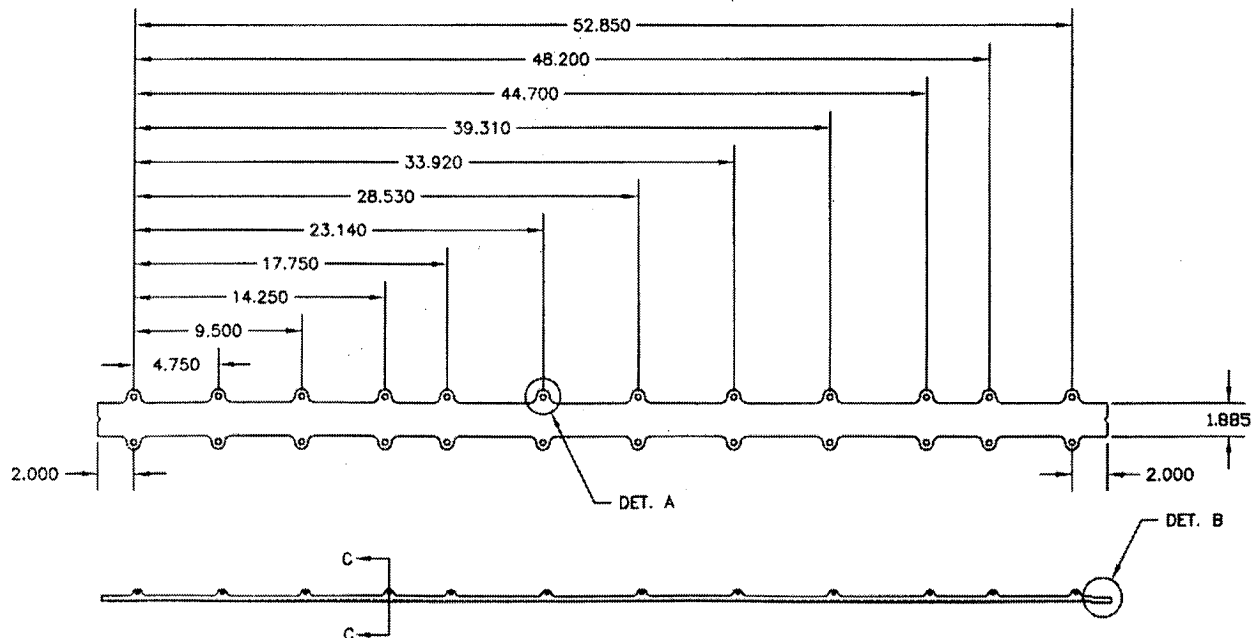


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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

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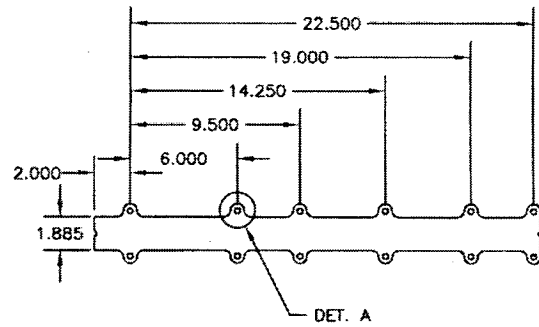
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86259

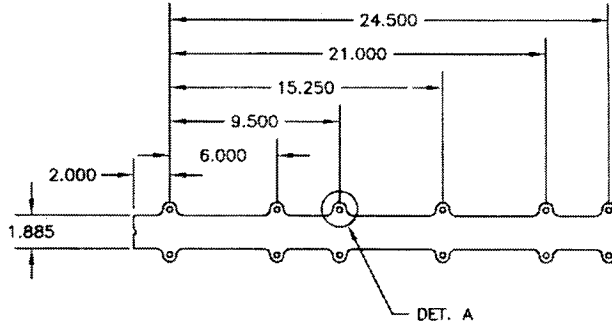


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		TITLE	WEARSHOE	SHEET 3 OF 4
		SCALE	1:10	

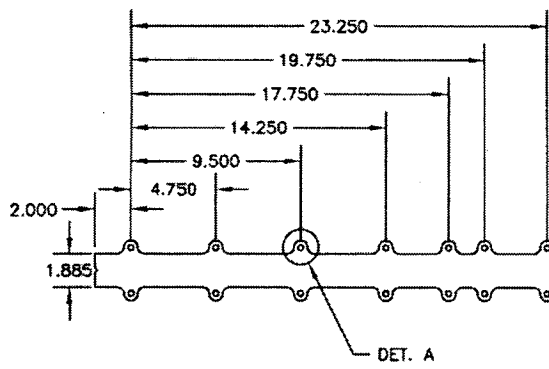
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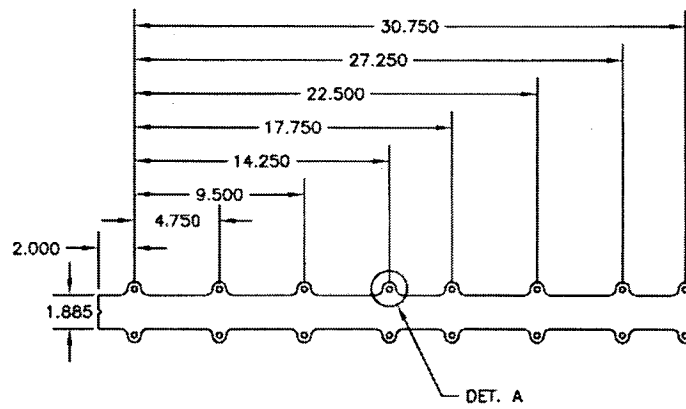
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D2656-35



D2656-37



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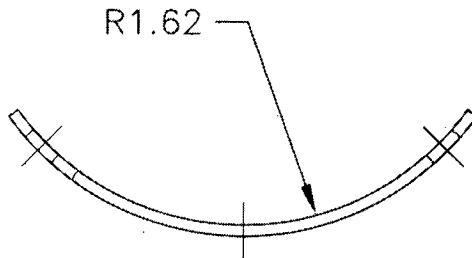
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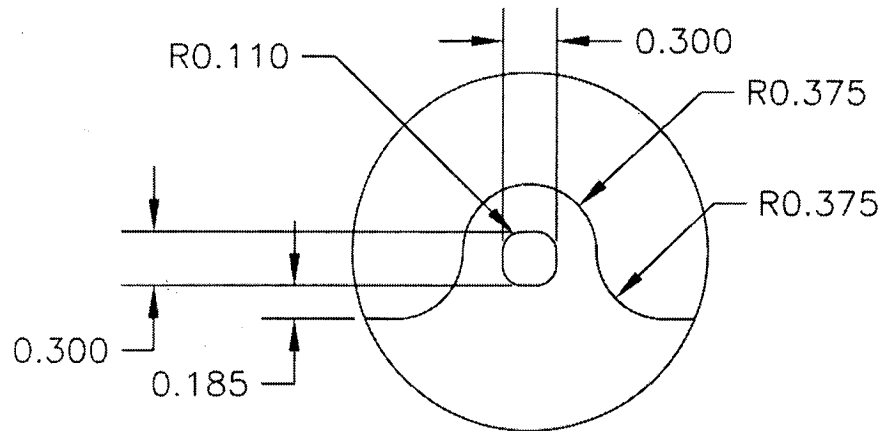
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CHECKED	APPROVED	DRAWING NO.	REV. D
<i>[Signature]</i>	<i>[Signature]</i>	D2656	SHEET 4 OF 4
DATE	TITLE		SCALE
05.08.17	WEARSHOE		1:10

SECTION C-C

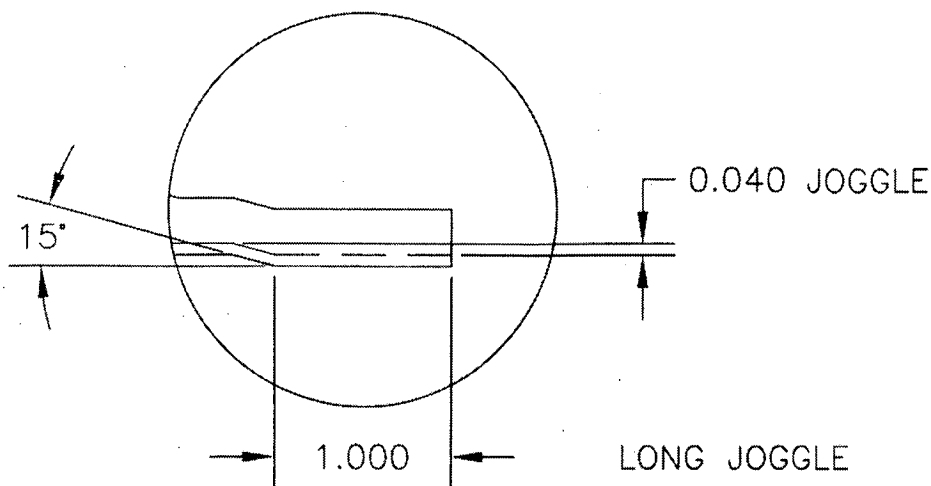


RELEASED
05.09.06

DETAIL A



DETAIL B



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